

Date: Monday, 5/1/2006 4:22:35 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	INLET WELDMENT (206)
Job Number :	26905		
Estimate Number :	10477		
P.O. Number :	N/A	Part Number :	D2413
This Issue :	5/1/2006	Drawing Number :	D2413 REV. A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	N/A	Material :	N/A
Written By :	<u>KJ</u>	Due Date :	6/30/2006
Checked & Approved By :	<u>KJ 06.05.02</u>	Qty:	4
Comment :	Est: C 06.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Heater Tube 4"

Qty	Part Number	Description	Batch
1	D2292	4" Ring	B27216

06/08/22 (4)

2.0	D2405	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 End Plate

Qty	Part Number	Description	Batch
1	D2405	End Plate	B24398

06/08/22 (4)

3.0	D2407	3" Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 3" Tubing

Qty	Part Number	Description	Batch
1	D2407	3" Tubing	B25064 (1) B26915 (3)

06/08/22 (4)

4.0	D2408	Locator Cross
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Locator Cross

Qty	Part Number	Description	Batch
1	D2408	Locator Cross	B26916

06/08/22 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 4:22:35 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET WELDMENT (206)

Job Number: 26905

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2409

Jet Pipe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Jet Pipe

Qty Part Number

Description

Batch

1 D2409

Jet Pipe

B27185

06/08/22 (4)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2413 Intake Assembly as per Dwg D2413 and QSI 004.

06/08/23 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-08-23 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

06-08-23

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

06-09-13 (4)

10.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1928

06/08/28 (4)

Red Anodize D2413 as per Dwg D2413

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached


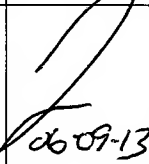
06/9/11 (4)


06-09-13 (4)


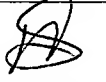


(PTO)

QC 315 Inspect anodize finish.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-09-13	10,0	Specify on Dwg what Mill spec. for Anodizing is required for these parts. Permanent change				 06-09-12	 06-09-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/10/02
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/15	14	when flaring the jet pipe crack at the end	 06-09-15	cut off crack + reflare	06.09.27 FF	 06-09-27	 06-09-27	 06-09-27

NOTE: Date & initial all entries

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Drawing Name: INLET WELDMENT (206)

Job Number: 26905

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN8188D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty Part Number
1 AN818-8D

Description
Flare Nut

Batch

M19413

FF 06.09.14 4

13.0

MS208198D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

Pick:

Qty Part Number
1 MS20819-8D

Description
Sleeve

Batch

M19099

FF 06.09.14 4

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2413. Sleeve & Flare tube as per Dwg D2413

FF 06.09.15 4

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SIS 06/09/27 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock -

Location: 54177

54177 Pack/box (4)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PS 06/10/02 (4)

Job Completion



w 06/10/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2413	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 INLET WELDMENT SCALE	

RELEASED
96/09/10 BW

QTY	Part No.	Description
X	D2413	INTAKE WELDMENT ASSEMBLY
1	D2292	4" RING
1	D2405	END PLATE
1	D2407	3" TUBING
1	D2408	LOCATOR CROSS
1	D2409	JET PIPE
1	AN818-8D	FLARE NUT
1	MS20819-8D	SLEEVE

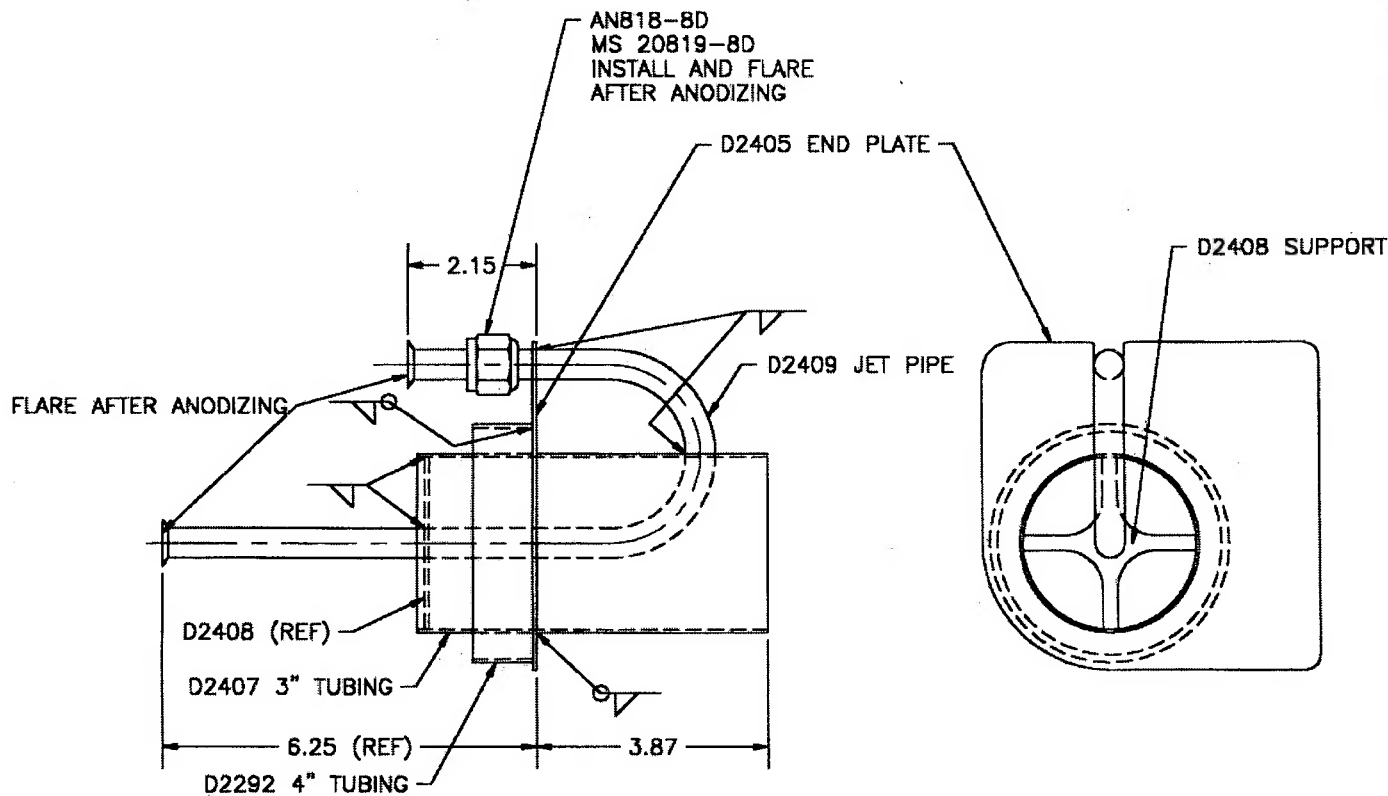
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 26905

DART



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2413	REV. A
DATE Apr. 6, 1995	TITLE 206 INLET WELDMENT	SHEET 2 OF 2	SCALE

RELEASED
9609/10 (54)



FINISH: ANODIZE

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26905

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

49686

06-Sep-2006

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:****PO00001928**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	4	4	D2413	B26905	MATL: AL STRIP RED ANODIZE PER MIL-A-8625F TYPE I CLASS 2

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐